

Work Order ID 119712

May-20-14 8:21:03 AM

119712

Page 1

Item ID: D4923-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate Assembly
 Start Date: 5/20/14 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 5/21/14 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 140520 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4923	A								

110	FLOW WATER JET	0.00							
110									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut D4923-1 as per Dwg Dwg Rev: <u>A</u> Prog Rev: <u>A</u> 2-Debur if necessary								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									

DAS
27
5/29

14/5/20

25 0 Jm14-05-20

25 0 Jm14-05-20

25
Cant

Work Order ID 119712

May-20-14 8:21:03 AM

119712

Page 2

Item ID: D4923-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate Assembly
 Start Date: 5/20/14 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 5/21/14 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* Brake NC Brake NC	Form as per dwg NC BRAKE Memo	0.00 0.00		DAS 30 9-89		25			14/6/20
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		SM 4/5/20		25			
160 *160* Large Fab Large Fab	Weld per dwg A/R S.S. rod Batch: <u>M126048</u> Large Fab Memo WELD BAR ON PLATE AS PER DWG	0.00 0.00				25		14-07-29	MAL

1 19712

May-20-14 8:21:03 AM

N900040100

Setup Start *NS1*

Stop ***NS2***

12

12

Reference:

Ruñ Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

170

65

14-07-30

DAS
9
~~9-89~~

180

(25)

14.07.32

DAS
9
9-89

240

25

DAS
28

9-89

JUL 31 2014

Work Order ID 119712

May-20-14 8:21:03 AM

119712

Page 4

Item ID: D4923-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearplate Assembly

Start Date: 5/20/14 Start Qty: 12.00

12

Cust Item ID:

Required Date: 5/21/14 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	QC21- Final Inspection - Work Order Release	0.00							
250									
QC	Memo	0.00							
Quality Control									

14/7/31

Picklist Print

May-20-14 8:21:02 AM

Page 1

Work Order ID: 119712

119712

Parent Item: D4923-041

D4923-041

Parent Item Name: Wearplate Assembly

Start Date: 5/20/14

Required Date: 5/21/14

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A 13.09.06 new issue DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4932-1-035		Manufactured	No				Each	5.0000		12			

D4932-1-035

KWS Carbide Wear Strip, 3.5" Long

**

25

14-07-29 MAL

B117742 x25.

Location

Loc Qty

Loc Code

WA001

5

116730

5

M304S16GA

Purchased

No

sf

286.1670

**

(2)

Jm14-05-20

M304S16GA

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

286.167

M127821

75.567

M128423

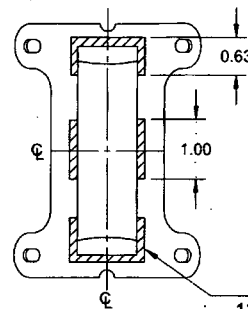
1.2

M129192

209.4

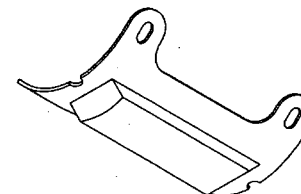
129992

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4923-041	WEARPLATE ASSY
1	1	D4923-1	WEARPLATE
2	1	D4932-1-035	KWS CARBIDE WEAR STRIP



D4923-041 WEARPLATE ASSY

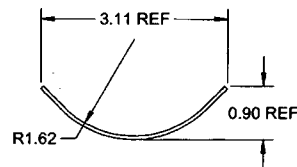
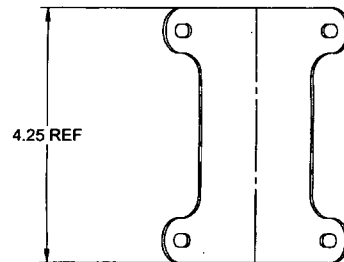
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 119712 ML5
14-05-20



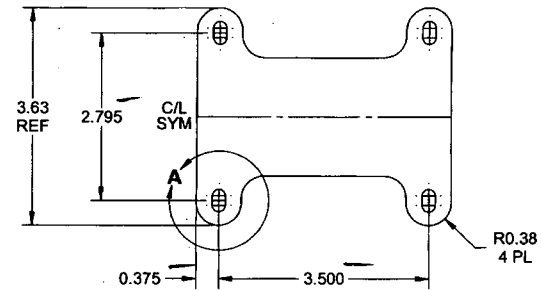
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4923-041" PER QSI 044 METHOD 6.1
 - 7) WEIGHT: 0.63 lbs
 - 8) WELDING: PER QSI 004

RELEASED
2014-04-04

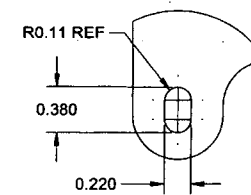
A	NEW ISSUE	DB	13.08.12
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	AP	D4923	SHEET 1 OF 2
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	WEARPLATE	NTS
DATE	13.08.12	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D4923-1 WEARPLATE
MAKE FROM D4923-1F



D4923-1F FLAT PATTERN



DETAIL A
SCALE 2X
4 PL

RELEASED
2014-04-06

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER AMS 5513, AMS 5524, MIL-S-5059, ASTM240 OR ASME SA240 16 GAUGE (0.063 THICK), (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.18 lbs

DESIGN	DB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	AP	D4923	SHEET 2 OF 2
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	WEARPLATE	NTS
DATE	13.08.12	COPYRIGHT © 2013 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			